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D3407-5
Job Sheet 197046



Part No: D3407-5

Job Qty: 2 pcs

Part Name: Ring



Part Weight: 0 lbs

Status: New

Priority: High

Job Created: 6/27/19

Job Tracking No:

Due Date: 6/28/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	6/28/19	6/28/19	0.17	0.18	Waterjet - Flow		SRB 6/27/19
							Waterjet - Omax		
110	QC 2	2 pcs	6/28/19	6/28/19	0.00	0.00	QC 2 - 1		SRB 6/27/19
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130	Packaging 3-1 - Stock - B4B	2	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA	2	6/28/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 53

E2

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DAS
70
9-89

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: G Prog Rev: A G 2-Break edges on manual lathe Dwg D3407
 Descriptions: (175rpm)

- 110 - (QC2- Inspect parts off machine FAI/FAIB)
- 115 - (Manufacture as per dwg)
- 117 - (QC2- Inspect parts off machine FAI/FAIB)
- 120 - (QC8- Inspect parts - second check)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-B0.250X4.000	17-4 SS H900 Bar 0.250" X 04.000"	.5320 ft (.266 ea)	100-Waterjet - Flow - 1	50 J5095

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M17-4-H900-B0.250X4.000	1	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches $\pm$ 0.010	0.260 0.240		
2	Tow Ring	3.000inches $\pm$ 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches $\pm$ 0.030	0.780 0.720		

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Container No: S194460



Part: D3407-5

Job No: 197046

Serial No/Batch: S194460

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/27/19

